

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005767**Date Inspected:** 17-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhong Boa Lei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG segment**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG outside assembly (OBG segment 5AW)

This QA received ZPMC Non Destructive Testing (NDT) notification No. 002288 and 002304 and performed Ultrasonic Testing (UT) of approximately 10% of the welds previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA generated a UT report for this date. The weld designations are as follows: SEG021A-004, 007, 008 and 010, lot tested SEG021*-009, 010 and 029 (lot testing covered SEG021*-011~026, 030~034), lot tested SSD14-PP031-002, 003 and 009 (lot testing covered SSD13-PP30-002, 003 and 009, SSD13A-PP30-002, 003 and 007, SSD13A-PP29-002, 003 and 007, SSD13-PP29-002, 003 and 009 and SSD14A-PP31-002, 003 and 009).

This QA along with Caltrans QA Mr. Eric Prue continued Phased Array Ultrasonic Testing (PAUT) training under the direction of NDT Professionals Inc. (NPI) technicians John Clark, Dave Johnson and Stefan Holms. Training was specific to equipment set up and scanning methods for crack detection on the Partial Joint Penetration (PJP) U-rib to deck panel welds.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the

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applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry (858)-344-2712, who represents the Office of Structural Materials for your project.

Inspected By:	Hall,Steven	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
